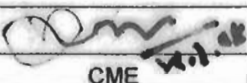
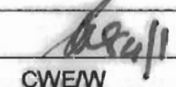
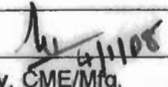



**GOVERNMENT OF INDIA
(Ministry of Railways)**

**SPECIFICATION FOR
SILICA SAND 130 AFS**

**MECHANICAL DRAWING OFFICE
RAIL WHEEL FACTORY
YELAHANKA, BANGALORE-560 064
INDIA**

**Issued by
SSE/D**

 CME	 CWE/W	 Dy. CME/Mfg.	 WM/MR
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SPECIFICATION FOR SILICA SAND 130 AFS**1.0 SCOPE**

- 1.1** The specification covers the manufacture and supply of sand - 135 AFS for the use of Graphite Mould Cleaning to Rail Wheel Factory, Yelahanka, Bangalore - 560 064, Karnataka, India as per the instructions and conditions of Contract and Tender Papers.

2.0 DESCRIPTION

Mould Cleaning Sand should conform to IS 1987: 2002.

3.0 GRAIN SIZE**3.1 RESTRICTIVE CHARACTERISTICS**

Fineness : 130 -150 AFS

3.2 INDICATIVE CHARACTERISTICS FOR GUIDANCE

Sieve Analysis:

1. Retention on US sieve 100 should not be more than 1%.
2. Retention on US sieve 140 should not be above 50%.
3. Retention on US sieves 140, 200 & 270 should be above 90%.
4. The distribution on sieves 140,200 and 270 should be so adjusted that the GFN works out between 135 to 150 AFS.

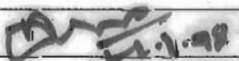



4.0 Shape : Predominantly sub-angular to round grain.

5.0 Silica content : 95% Min.

6.0 Clay content : 2% Max.

7.0 Moisture content : 0.5% Max.

- 8.0** The sand should be dried. It should be from Natural source i.e., from riverbed, desert or sea. CRUSHED QUARTZ IS NOT SUITABLE.

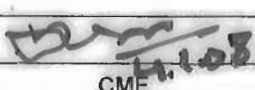

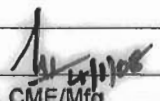
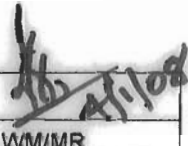
			
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9.0 The sand should be free from any foreign particles such as Fibres, Grass Roots and Clay Dust etc.

10.0 The sand should be supplied in polythene lined new gunny bags each containing 25 kg. Usage of eco friendly biodegradable packing lining material is preferable.

11.0 SAMPLING NORMS

As per IS: 1811-1984- Methods of sampling Foundry sand

			
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